

Date: Thursday, 2/9/2006 1:38:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 25755A	Part Number	: D2989041
Estimate Number	: 10206	Drawing Number	: D2989 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/9/2006	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/28/2006
Previous Run	: 25614A	Qty:	1
Written By	: SEE COMMENT BELOW	Um:	Each
Checked & Approved By	: KJ 02.02.10		
Comment	: Est Rev:1 Removed D2989-043 05-11-03	JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31663	Basket Hoop	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty.(1) D3166-3 Batch: B25896	PD 06-02-27
2.0	D2581	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
		2 D2581 Mounting Brackets B2589	PD 06-02-27
3.0	D23273	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
		2 D2327-3 Bushing B24874	PD 06-02-27
4.0	D2506	Placard	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
		1 D2506 Label Plate B24875	PD 06-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2989041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number Description Batch

15sf M304EX0.75-16F Expanded Metal

M100027

PD ob-02-27

6.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M100138

PD ob-02-27

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

PD ob-03-02

8.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD ob-03-02

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

DC ob-03-04

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: M19660

Wing Walk: M10037

PLC ob-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2989041

Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		<i>26-03-08</i>
11.0	DC	DOCUMENT CONTROL
		<i>① 06/03/09</i>
Comment: Inspect Powder Coat and Wing Walk		
Comment: DOCUMENT CONTROL Inspection Level 21		

Job Completion



U 06-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY		SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

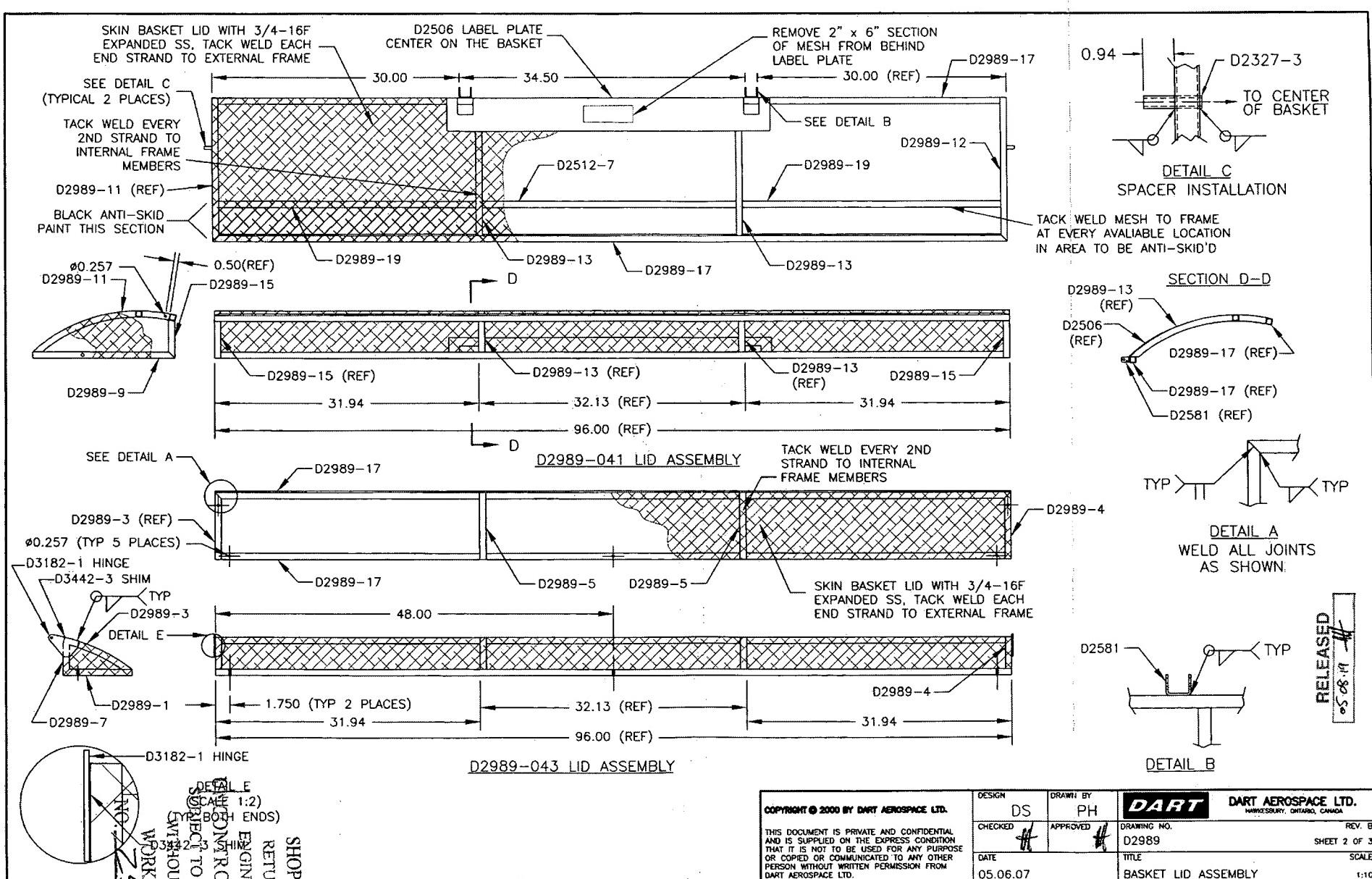
05-08-19

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
	1	D2989-9	STRUT
	1	D2989-10	STRUT
	1	D2989-11	STRUT
	1	D2989-12	STRUT
	2	D2989-13	STRUT
	2	D2989-15	STRUT
	2	D2327-3	SPACER BUSHING
	1	D2506	LABEL PLATE
	2	D2989-17	STRUT (96.00" LONG)
	2	D2989-19	STRUT (31.19" LONG)
	1	D2512-7	STRUT
	2	D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

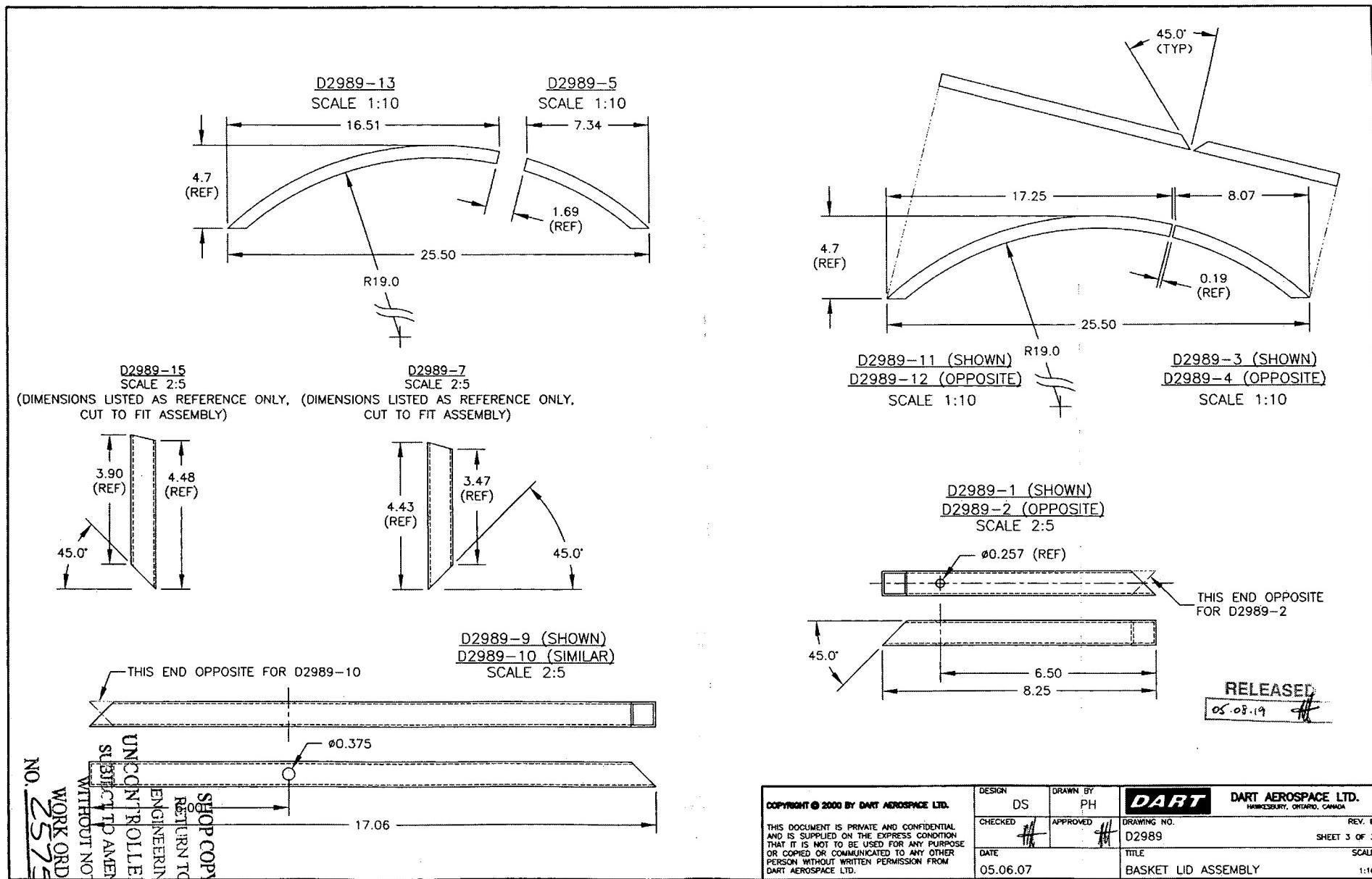
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236 SHOP COPY
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F) RETURN TO ENGINEERING
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3. UNCONTROLLED COPY
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SUBJECT TO CHANGE
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID. WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER
NO. 25755A



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH		REV. B
CHECKED	APPROVED		SHEET 2 OF 3
DATE	05.06.07	DRAWING NO. D2989	SCALE 1:10
		TITLE BASKET LID ASSEMBLY	



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	DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SHEET 3 OF 3
				SCALE 1:10

RELEASED
05.08.19